

Work Order ID 150627

Monday, August 29, 2016 2:50:14 PM

Page 1

Item ID: 646.3910

Revision ID:

Item Name: Shim

Start Date: 8/8/2016 Start Qty: 10.00

Required Date: 8/29/2016 Req'd Qty: 10.00

Reference:

646.3910
B150627
REV. N/C1

Accept

150627***N900040100***Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: AUG 30 2016 Tooling: _____ Date: _____QC: DAS Date: _____ SPC (Y/N): _____ Date: _____
21
9-89Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

646.3900	nc1
----------	-----

110

0.01

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: NC 1Prog Rev: NC 1

2-Deburr if necessary

0.05

18dc 11/09/12

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.02

18dc 11/09/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 150627

Monday, August 29, 2016 2:50:14 PM

150627

Page 2

Item ID: 646.3910

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 8/8/2016

Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/29/2016

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.03

Quality Control

18

38
9-89

SEP 13 2016

140

Outsource process-Cadplate per OSI017 4.1.9.1

0.00

140

Outsource3

Memo

399.98

Outsource process - Cad plate

Issue P/O: 33274
Cad Platting

18

SEP 27 2016

DAS
13
9-89

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.03

Packaging

18x SP/6-10-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

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NS1

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Stop

NS2

Item Name: Shim

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Start Qty: 10.00

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Cust Item ID:

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Req'd Qty: 10.00

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Customer:

Reference:

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Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.03

Quality Control

12

DAS

38

9-89

OCT 11 2016

170

Identify as per dwg & Stock Location: CK106

0.00

170

Packaging

Memo

0.02

Packaging

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

18

OCT 12 2016

DAS

6

9-89

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.17

Quality Control

DAS

21

9-89

OCT 13 2016

DAS

21

9-89

OCT 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

Picklist Print

Monday, August 29, 2016 2:50:13 PM

Page 1

Work Order ID: 150627

150627

Parent Item: 646.3910

646.3910

Parent Item Name: Shim

Start Date: 8/8/2016

Required Date: 8/29/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020		Purchased	No			110	sf	14.3000	0.03	0.31579			

MC1095S 020

C1095 Blue Tempered Spring Steel Sheet .020 mcmaster p/n: 9036K499

2x 16/09/12

Location

Loc Qty

Loc Code

MAT019

14.3

M130477

2.3

M135525

12

.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :																						
Misidentified ☐	☐	Past Due ☐																							



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05243

SHEET 1 OF 1

DWG NO. 646.3900

REV: N/C PREPARED BY J. BECKER

DATE: 11/13/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: SHIM

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

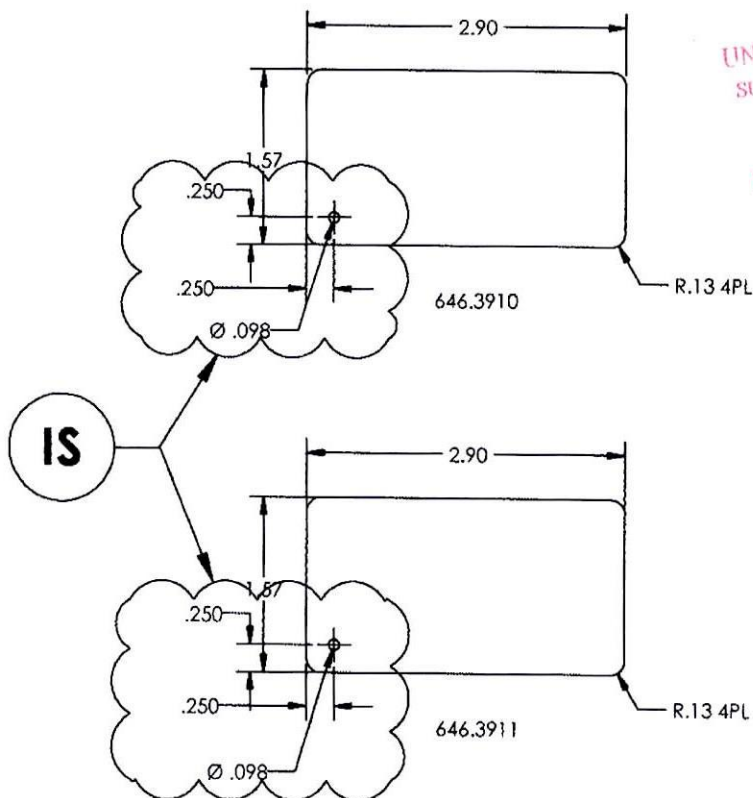
REASON: REVISED VIEWS. UPDATED TEMPLATE AND TITLE BLOCK.

ECR:

15-275

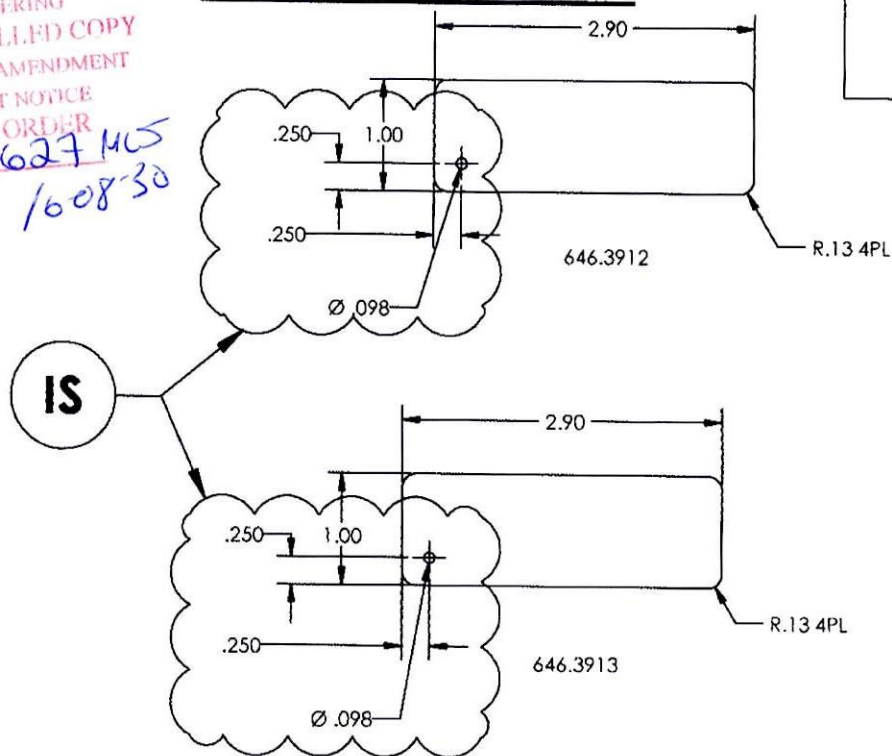
ACTION ITEM:
1. N/A.

SHEET 1, ZONE B2 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150627 MJS
160830

SHEET 1, ZONE B5 IS:



SHEET 1, ZONE C2 IS:

SHEET 1, ZONE C5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

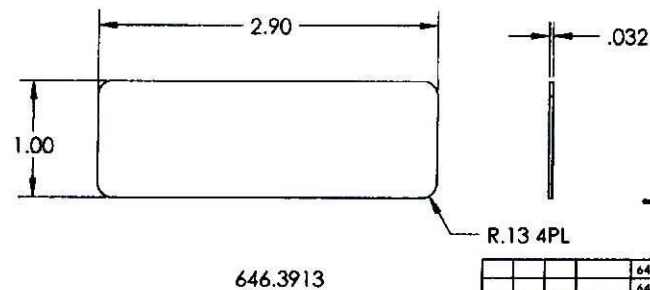
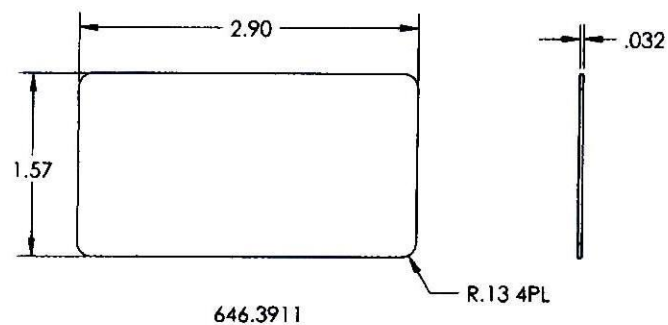
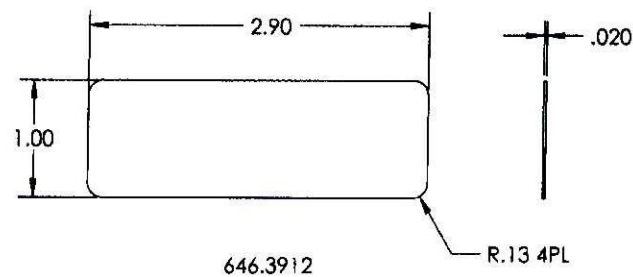
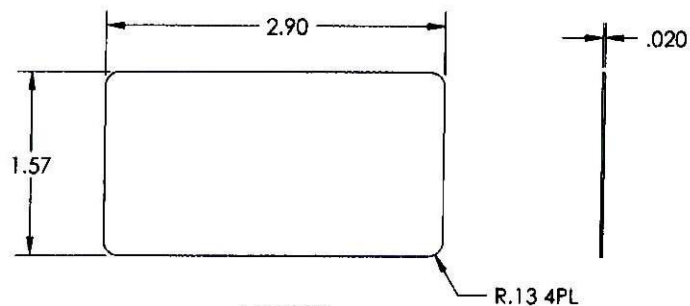
☐ YES ☒ NO

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

NOTES:

- 1 MATERIAL: SHIM STOCK, C1095 BLUE-TEMPERED SPRING STEEL
- 2 FINISH: CAD PLATE PER QQ-P-416 TYP II CL2
- 3 IDENTIFY IAW MPP-120



UNINCORPORATED ECN(s)

05243

		646.3913	SHIM	▲	▲
		646.3912	SHIM	▲	▲
		646.3911	SHIM	▲	▲
		646.3910	SHIM	▲	▲
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY	PARTS LIST				
NEXT ASSY (S)	APICAL INDUSTRIES				
646.4000	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300				
	SHIM				
	NET	CAGE CODE	DATE	REV	
	B	07M16		646.3900	N/C
	SCALE NONE			SHEET 1 OF 1	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33774**

Purchase Order Date 9/27/2016

PO Print Date 9/30/2016

Page Number 1 of 3

Order From :

VC-ALT01

Ship To : DART AEROSPACE LTD

GROUP ALTECH
2455 HALPERN

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

ST LAURENT, MONTREAL H4S 1N9

Contact Name

Vendor Phone 514-335-3666

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FOB Origin

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
2	150715	646.3912 shim	10/12/2016 Yes 10/12/2016		25.00	\$3.51	\$87.80
	CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2						
						Line Total:	\$87.80
3	150218	646.3910 shim	10/12/2016 Yes 10/12/2016		17.00	\$3.51	\$59.70
	CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2						
						Line Total:	\$59.70
4	150627	646.3910 shim	10/12/2016 Yes 10/12/2016		18.00	\$3.51	\$63.21
	CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2						

Note:

9/30/2016

Sp/6-10-11



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.:(514)335-3666 Fax.:(514)335-3868
Internet : www.groupaltech.com

Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance

Bon-Livraison / Pk.Slip # : 121781-1 05/10/2016
Bon-Commande. / W.Order # : 121781
Client P.O. # : 33774
Transport :

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	<u>No. Job</u> <u>No. Réf</u>	<u>NoSerie / Part Number</u> <u>Nom Produit / Product</u>	<u>Traitement</u> <u>Process</u>	<u>Poids</u> <u>Weight</u>	<u>Qté</u> <u>Qty</u>	<u>Envoyé</u> <u>Sent</u>	<u>A venir</u> <u>BO</u>
1	UNIT	646.3912 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:2	0.00	25	25	0
2	UNIT	646.3910 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:2	0.00	17	17	0
3	UNIT	646.3910 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:2	0.00	18	18	0
4	UNIT	D3028-1 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1	0.00	20	20	0
5	UNIT	D212-725-1-111 Rev. ENGINE MOUNT	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1	0.00	4	4	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.
We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.